

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D2590-041	SKIDTUBE ASSEMBLY
1		X	D2590-043	SKIDTUBE ASSEMBLY
2	1	1	D2500-1-190	EXTRUSION
3		16	D2570	BUSHING
4	1	1	D2576-3	STEP
5	10	4	D2594-1	PLUG
6	10	4	D2594-3	O-RING
7	1	1	D2597	204 WEB
8	1	1	D2855	AFT CAP
9	1		D3564-7	WEARSHOE
10	1		D3564-9	WEARSHOE
11	1		D3564-11	WEARSHOE
12	1		D3564-13	WEARSHOE
13	17	22	D4202-1	SPACER
14		1	D4408-041	WEARPLATE ASSEMBLY
15		1	D4408-043	WEARPLATE ASSEMBLY
16	44		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
17	44		AN3C4A	BOLT
18	2	2	AN3-5A	BOLT
19		8	AN4-45A	BOLT
20	44		NAS1149C0332R	WASHER (AN960C10L)
21	2	2	NAS1149D0332J	WASHER (AN960JD10L)
22		8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB
POWDER COAT ASSEMBLY GLOSS WHITE 4.3.5.1 PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2590-041 = 30.6 lbs
D2590-043 = 33.3 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO
OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE
BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND
ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS
ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8218 ONLY FOR D2590-041 TO LOCATE AND DRILL Ø0.297
HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (44 PLACES)
AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-
291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
AFTER FINISH (10 PLACES FOR D2590-041 AND 8 PLACES FOR D2590-043).
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION.

G	SHEET 1 : PL DELETE D3566-1/-7/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEET 2 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	18.12.14
F	INCORPORATE DEO D2590-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2590-043; DT8218 WAS TD2577-204 (ZN C4-1); REFORMATTED DRAWING TO CURRENT STANDARDS	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.28
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>df</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	ZF	DRAWING NO.	REV. G
MFG. APPR.	DD	D2590	SHEET 1 OF 6
APPROVED	<i>No</i>	TITLE	SCALE
DE APPR.	<i>df</i>	204 SKIDTUBE ASSEMBLY	NTS
DATE	18.12.14	COPYRIGHT ©1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
44 PL

REFER TO DETAIL A

D3564-11

D3564-7

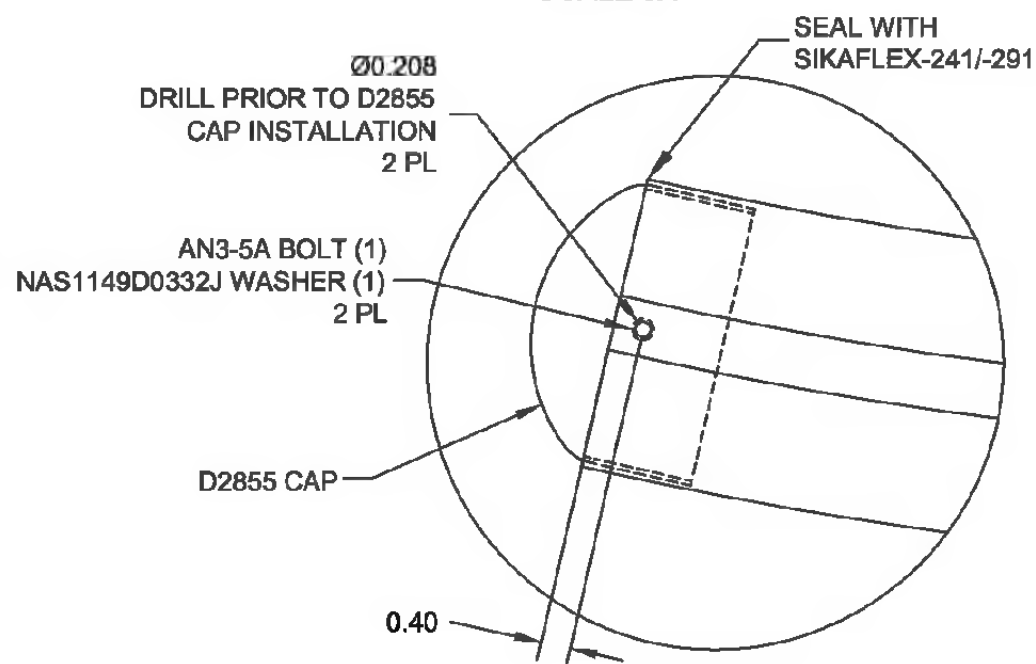
D3564-9

D3564-13

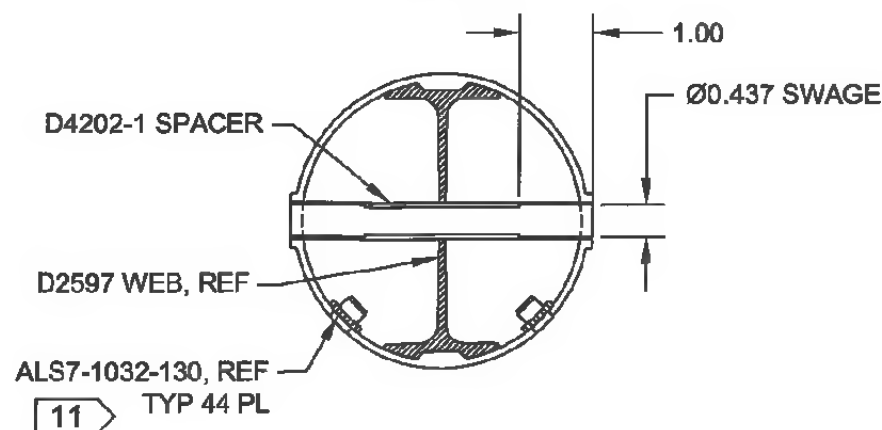
D2590-041 ASSEMBLY DETAIL



DETAIL A SCALE 5X



SECTION B-B SCALE 5X

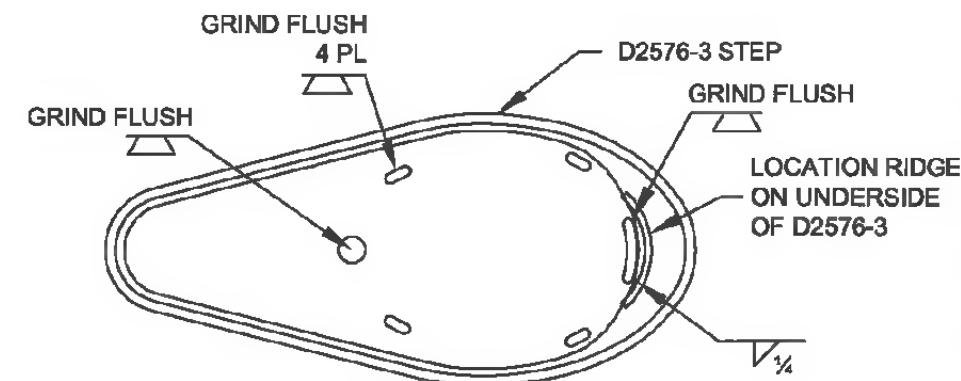


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (17 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

RELEASED

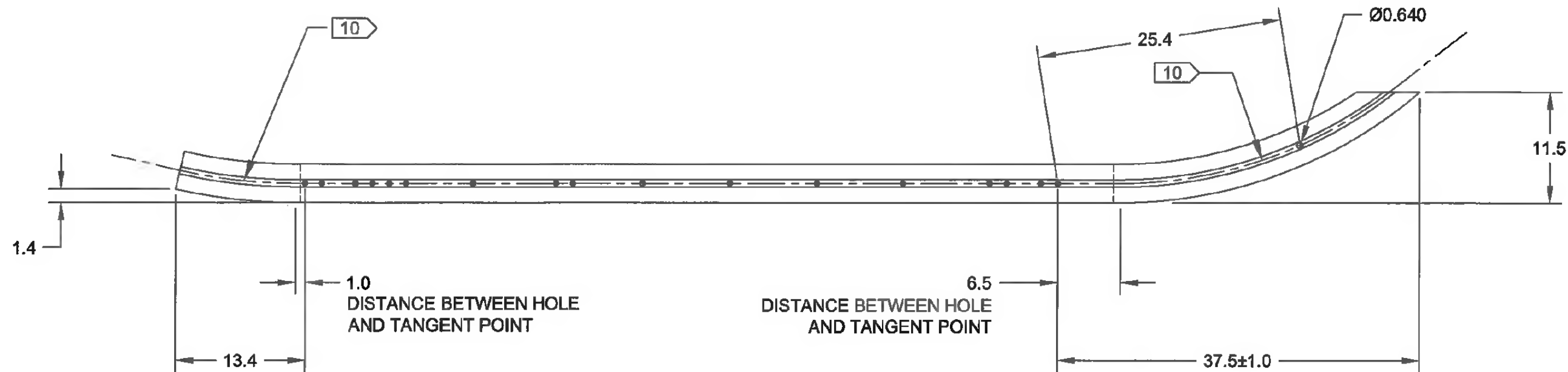
2018 DEC 13

DETAIL C SCALE 4X



DESIGN	4	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. G
MFG. APPR.	DD	D2590	SHEET 2 OF 6
APPROVED	ND	TITLE	SCALE
DE APPR.	4	204 SKIDTUBE ASSEMBLY	NTS
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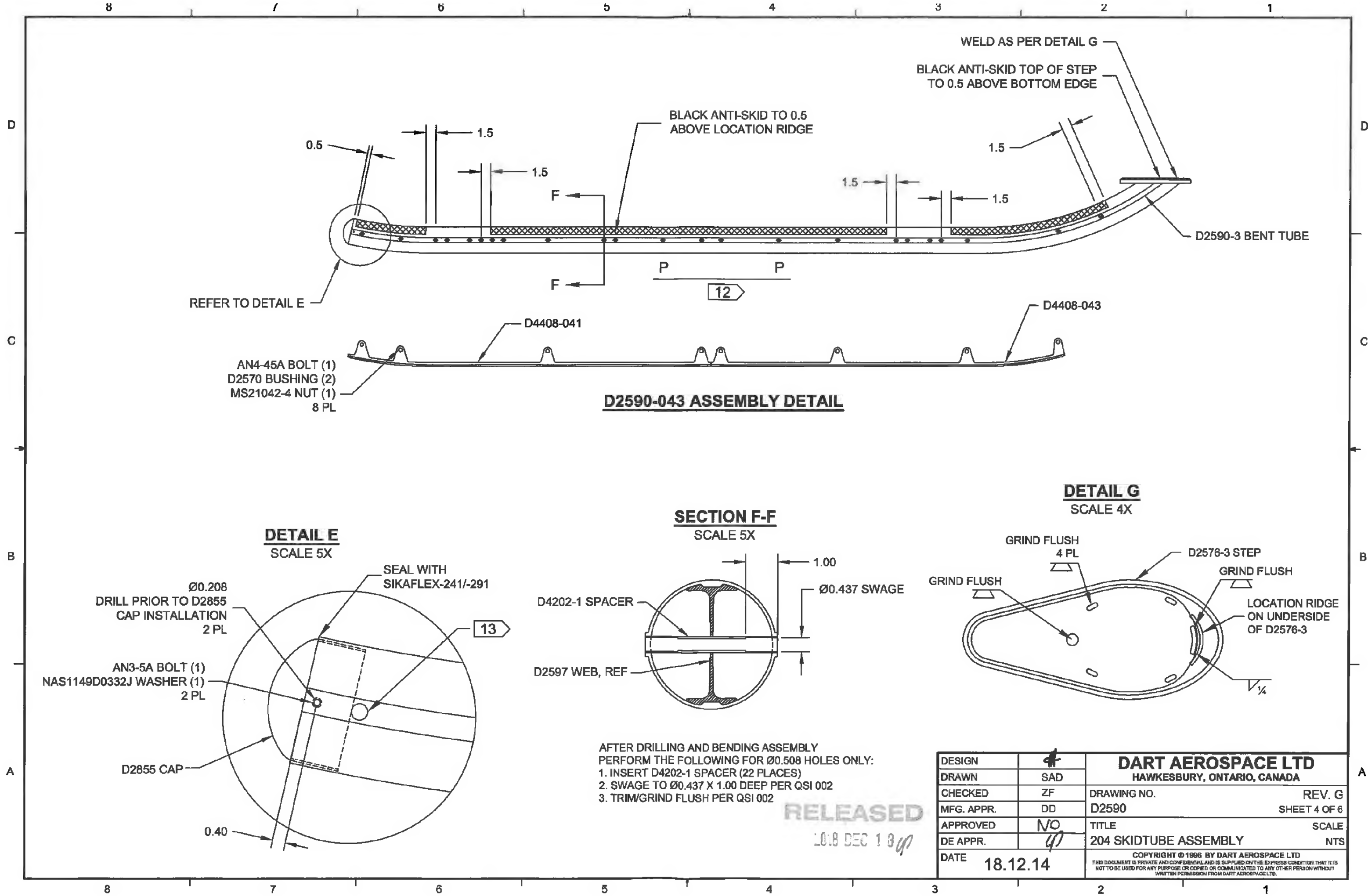
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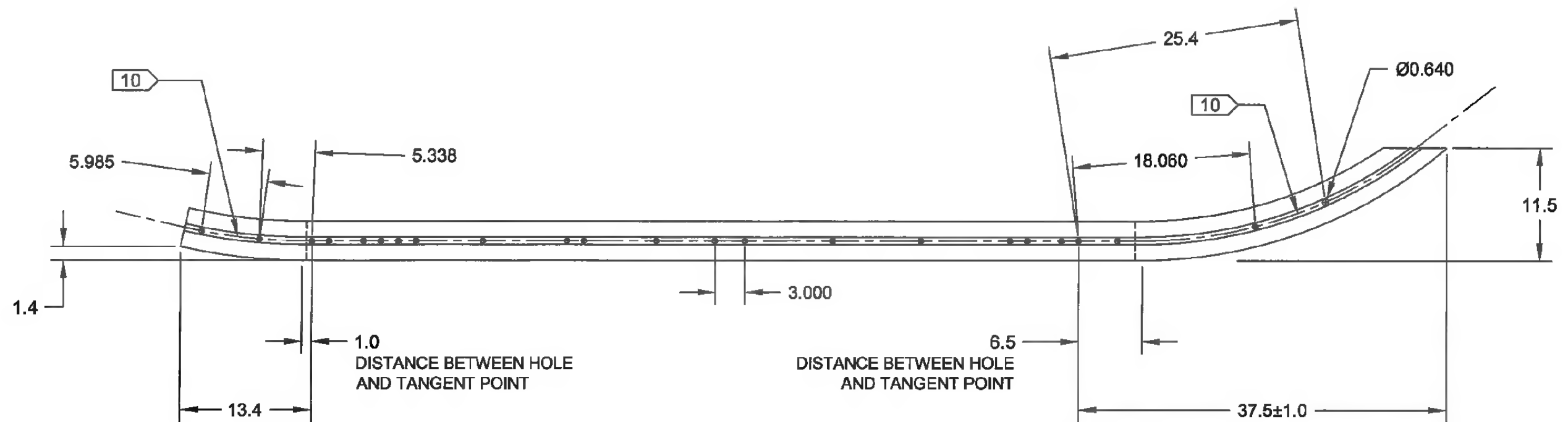


D2590-1 BENT TUBE
(MAKE FROM D2590-101 TUBE)

RELEASED
2018 DEC 13 *up*

DESIGN	<i>4</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	ZF	DRAWING NO. D2590	REV. G
MFG. APPR.	DD		SHEET 3 OF 6
APPROVED	<i>No</i>	TITLE 204 SKIDTUBE ASSEMBLY	SCALE
DE APPR.	<i>up</i>		NTS
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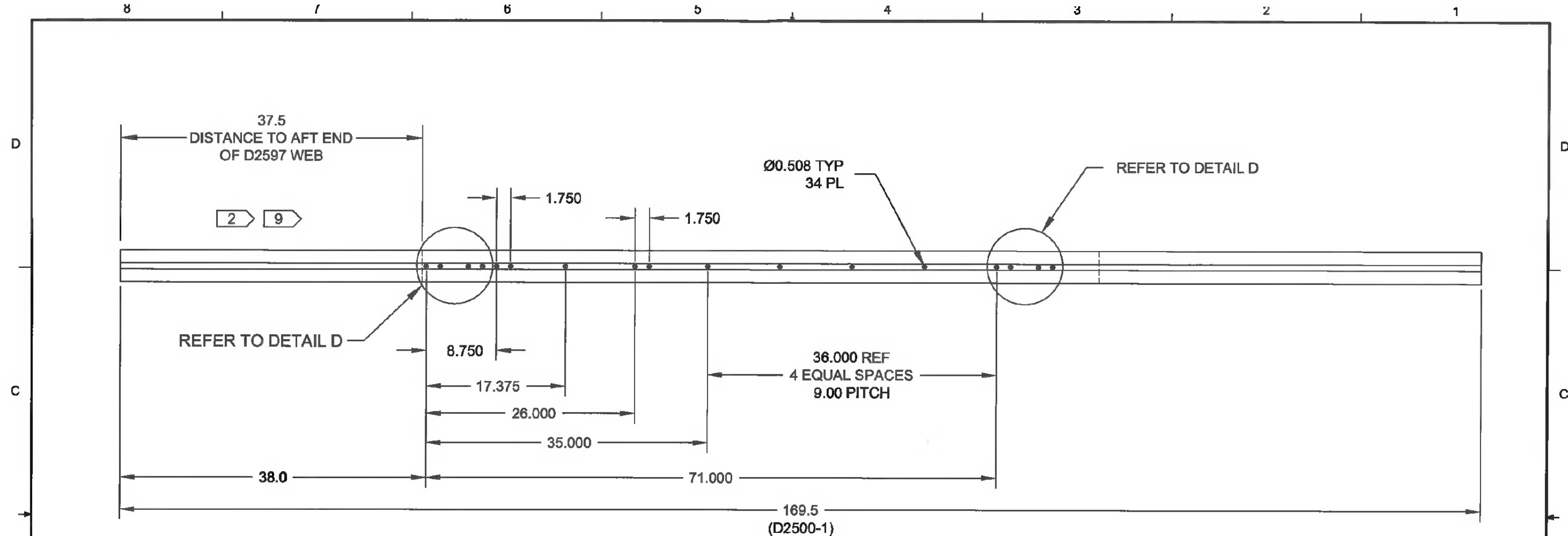


D2590-3 BENT TUBE
(MAKE FROM D2590-101 TUBE)

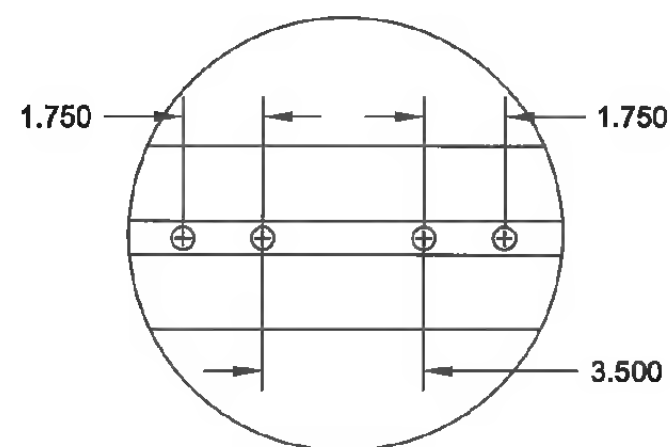
RELEASED

2018 DEC 13

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	ZF	DRAWING NO.	REV. G
MFG. APPR.	DD	D2590	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	204 SKIDTUBE ASSEMBLY	NTS
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D2590-101 TUBE



DETAIL D
SCALE 5X

RELEASED
10:9 DEC 13

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	ZF	DRAWING NO.	REV. G
MFG. APPR.	DD	D2590	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	204 SKIDTUBE ASSEMBLY	NTS
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